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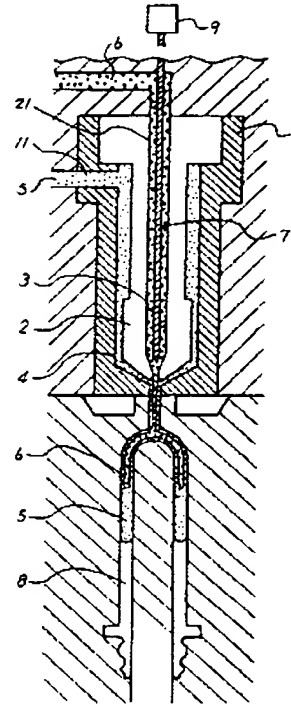
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TITLE : INJECTION HEAD FOR
MULTI-LAYERED PARISON MOLDING



ABSTRACT : PURPOSE: To enable the thickness of a multi-layered parison to be adjusted accurately and freely by keeping a cylindrical body at the position wherein a ring nozzle is released at all times, and providing, within a central nozzle, a valve pin which serves to open and close only the central nozzle.

CONSTITUTION: Between a cylindrical body 2 and an injection head 1, a ring nozzle 4 is formed, and PET resin 5 flowing from a sprue 11 is discharged from the top end into the mold cavity 8. At the center of the cylindrical body 2, a central nozzle 3 is formed, the barrier resin 6 injected is discharged from the top end passing through the central nozzle 3. The barrier resin 6 is held between the PET resin 5 discharged from the top end, and transformed into a multi-layered one and discharged then into the mold cavity 8. When a valve pin 7 laid within the central nozzle 3 is advanced, the top end thereof engages inwardly in the top end of the central nozzle 3 so as to open and close this, thereby adjusting the discharge rate of the barrier resin 6. The valve pin 7 penetrates through the rear end of the central nozzle 3, and moved fore-and-aft by a hydraulic cylinder 9 or the like.

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